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PRODUCT: ALL DIPPED
TURKEY BREAST (SKIN ON) SWIFT

Q

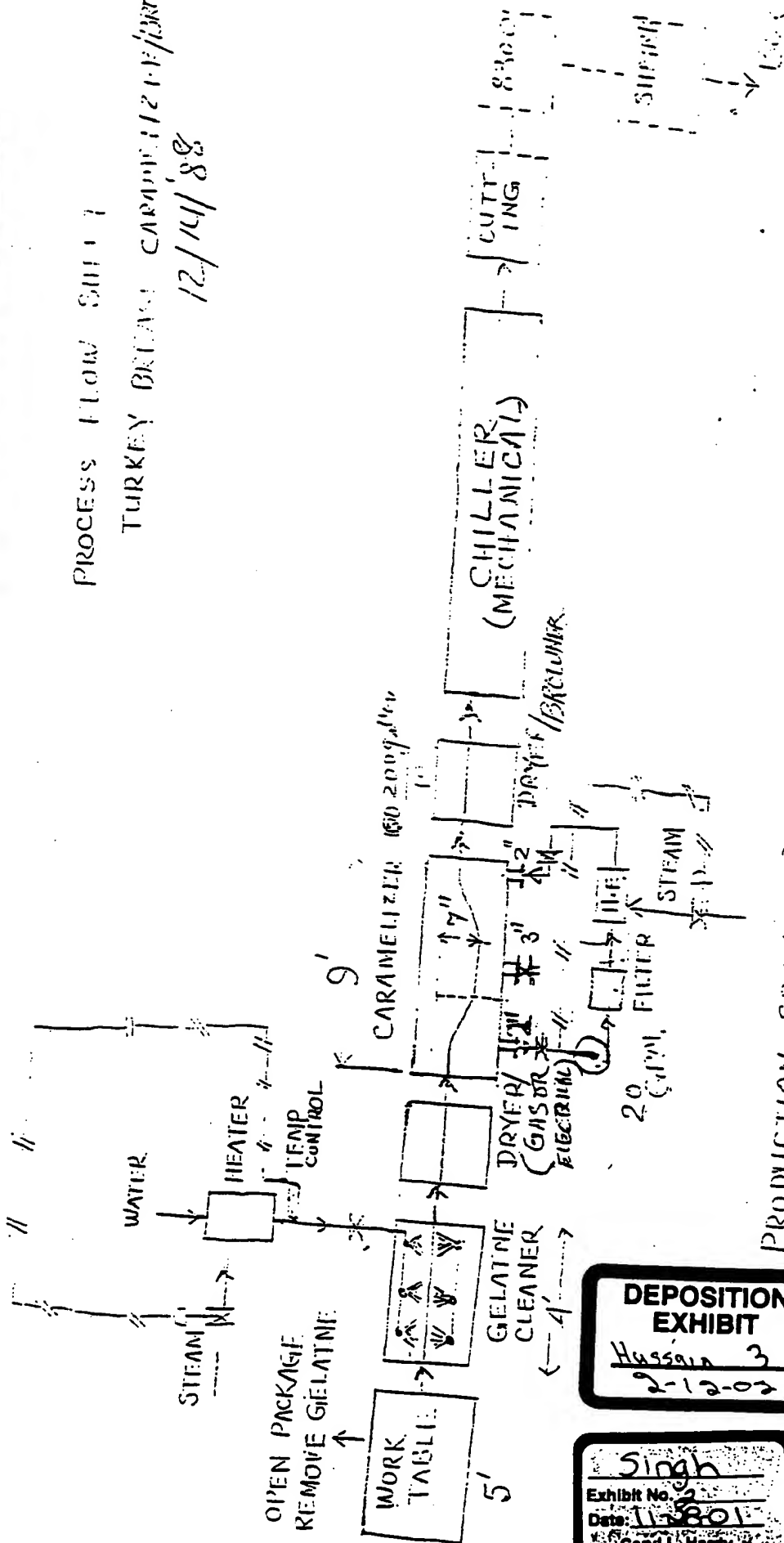
10/14/93

U-06221

[illegible]

PROCESS FLOW SHEET

TURKEY BREADED CARAMEL 12 1/2 P/BARS
12/14/88



PRODUCTION SPEED - 20 PIECES/MINUTE/UNCUT
 CARAMEL TIME - 20-25 SECONDS (BREADED TIME)
 PRODUCT TEMP - 40°F (AT THE WORK TABLE)
 PRODUCT FROM CHILLER MUST BE AT 40°F OR LOWER
 PRODUCT FROM BOTH DRYERS MUST BE DRY TO THE TOUCH
 PROCESS PIPING AND CONTROL SUPPLIED BY [unclear] / [unclear]

DEPOSITION
EXHIBIT

Hussain 3
2-12-02

DEPOSITION
EXHIBIT

Sch 3
2-13-02

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CRPF04014

Exhibit No.

Date

Caryl L. Hardy

PTO-002170

7-73-92
pgw.

Liquid Smoke
(Hickory Specialty, Super 10/poly)

(1) 2 1/4 gal H₂O + 3/4 liquid smoke

(2) Heat to boiling point

(3) (A) pre-cooked whole Turkey (Dip 60 sec)

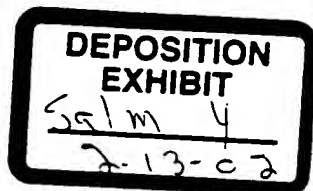
(B) pre-cooked whole Turkey (Dip 30 sec)

(C) B.B. Stoullers Deli Breast (Dip 45 sec)

(4) Heat Processing

* product out of hot liquid smoke look
very yellowish color.

* Can not tell difference between 60 sec vs. 30 sec treatment	<u>D</u> 145	<u>W</u> 0	<u>I</u> 30	product look light but some browning color
	160	130	30	Whole bird look light golden brown * Stoullers Breast has color and pale
* There is no skin separation at the breast	160	0	30	Whole bird look golden brown * Stoullers breast look roast coffee color



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CRPF00477

10-29-95
JPH

Liquid Smoke Test

(A) Liquid Smoke: 12A (Smoked Turkey)
92-46

PH: 6.7

1 gal h.s. + 2 gal H₂O

(B) Treatment:

3 Birds were used (Came from Cather, Pre-pumped).

- ① h.s. solution warm up to 170°F
- ② (a) one bird soaked 1/2 min
- (b) one bird " 1 min
- (c) one bird " 1 1/2 min

(C) Heat Processing

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Before next cycle
C > b > a
C is golden brown already
a is the lightest, but
some brown. Heat
completely cooking

	D	LV	T	INT
	175	110	90 min	90 °F
	185	145	60 min	118 °F
	185	175	24/36 min	162 °F

took 30 min to reach
162 °F change house

CRPF00643

Yield

(c) 1 1/2 mi L.S. Siding

14.08	
<u>11.90</u>	after S.H.
84.52%	
<u>11.56</u>	after soil (re-mixed)
<u>82.10</u>	

(b) 1 mi

13.30	
<u>11.48</u>	after S.H.
86.32%	
<u>11.18</u>	
<u>84.66</u>	

(a) 1/2 mi

12.78	
<u>10.50</u>	
82.16%	

* Product after shower looks like 79.34 ~~like~~ the yellowish background.

* (a) sample had less shower, the cavity did not fill with water

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* Product after overnight chills (a) looks most closed to control. (c) is too dark look like Armour smoked Turkey. However, the color more at gray side and lack of yellowish background. and the wing is too dark

CRPF00644

PTO-002173

h. S. Test
(Smoked Turkey)
D W I

11-2-92
pym

175 110 1hr 1st Briel
175 110 1hr 2nd Briel

Σ Ari = 40 p31

* 1st Briel no color } L.S. = 5.8 lbs / 75 min test
* 2nd Briel much } Densit = 5 lbs
more yellowish color 175 0 10 12amps closed

185 145 30

185 175 3hr 15m 160 OF TWT

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* It was interesting to notice that
the dryer surface pick up less
liquid smoke and lighter color.

This never happens to the regular
Charcoal Supreme Liquid Smoke

CRPF00645

* After overnight drying, 1hr dry gave
the best color, but turns down a little late test

Select A
Mallory
John Sloops
sample

T2

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Select A

475°F/400°F¹⁴
Cut bottom 1/2

HEAT
11.7

PROD
11.7 (AFTER
CUT)

FIN
1.7

3/12/93 Per
2

8.81

8.40

1.13

96.7. Jumping 2
Pole

10.22

9.76

0.12

96.6 1.8

43'10

8.95

8.50

0.12

96.3 0.8

27.98

26.66 - 37

27.41

26.66

MALLORY

96.56

2A for
cell
N2

T2

3000 PH 2.8

9.49

9.12

F 0.12

97.3 480F 1.2
Mallory

9.01

8.64

0.12

96.86 3000
Cut bottom 2

43'18.41

8.02

0.12

96.74 3000
Cut bottom 0.8

9.27

8.79

0.12

96.06 3000
Cut bottom 1.2

34.57

T1

Mallory

96.14 2910
Cut bottom 1.8

9.36

6.84

0.12

95.67 2
Cut bottom 4

40% 9.28

void

8.70

0.12

95.00 2
Cut bottom 4

8.85

8.18

0.12

93.70 1.8
Cut bottom 4

7.09

8.56

0.12

95.42 4.85
Cut bottom 4

8.96

8.24

0.08

94.95 4.85
Cut bottom 4

34.28

43'10 8.95

8.37

0.12

94.8 = 94.79'10

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CRPF04865

9.72
9.7 → 134
9.26

Control **CONFIDENTIAL**

	Before	after	Same as →
	8.24	7.76	T-2
136	9.26	8.65	Conditions
	7.76	7.72	3/12/93
	<u>25.26</u>	<u>24.13</u>	95.52%

T₁

	7.74	6.76	93.38 (119.50 max wt)
	7.04	6.80	
145	7.32	6.48	124 (121) ↓ plant
	7.38	6.94	
	<u>7.52</u>	<u>7.12</u>	
	<u>37.00</u>	<u>34.10</u>	92.16%

T₂

	10.70	9.94	90.72% (131.5)
	8.94	8.30	
148	9.84	9.08	
	<u>29.48</u>	<u>27.32</u>	92.67%



LFB



Mailloss

90.94%
(134.59)

3/16/93

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CRPF04866

PTO-002176

CONTROL

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	TOTAL	Meat	Btg	Purge	7. Pa
①	10.74	9.74	0.10	0.90	8.52
②	8.74	8.00	0.10	0.64	7.48
<u>Test 1</u>	8.69	8.34	0.16	0.19	2.29
	8.53				
<u>Test 2</u>	8.94	8.64	0.12	0.18	2.02
	8.82				

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CRPF04867

TEST (2A)

COOK + SMOKE BUTTERBALL

180° C.U.T
 $T_{IN} \approx 41$ in
 WEIGHT = 9.06
 = 8.86

BOX + N₂

BOX + N₂ + TROD

BOIL-OFF
 .041 g/min

1:20 64.8
 1:27 64.3
 1:32 64.1
 1:38 63.7
 1:44 5
 1:48
 1:53
 1:56
 2:01
 2:05

72.56
 57.3
 53.2
 49.5
 47.7
 46.0
 45.7

1.08 ± BOIL-OFF

So: 25.78 ± N₂

= 2062.4 BTU

⇒ ΔBTU = 130.40

1/4" 87°
 1" 55°
 Core 42°
 Surf 94°

Chill curve 3/23/93
 N₂ Equilibrium
 Condition as 2A
 maittoze / net

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CRPF04868

Controls (27.46)

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3/

	TOTAL (w/o Bag)	meat	Bag	Purge	
①	9.21 (9.07)	8.24	0.14	0.83	9.2%
②	10.02 (9.92)	9.26	0.10	0.66	6.7%
③	8.57 (8.47)	7.76	0.10	0.71	8.4%
TEST-1 25.26					

①	8.03 (7.93)	7.74	0.10	0.19	2.4%
②	7.25 (7.13)	7.04	0.12	0.09	1.3%
③	7.32 (7.40)	7.32	0.14	0.08	1.1%
④	7.65 (7.51)	7.38	0.14	0.13	1.7%
⑤	7.74 (7.62)	7.52	0.12	0.10	1.3%
TEST-2 (37.5) 37.00					

①	10.12 (10.00)	9.84	0.12	0.16	1.6%
	9.23 (9.11)	8.94	0.12	0.17	1.9%
③	11.05 (10.93)	10.70	0.12	0.23	2.1%
20.04 29.48					

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CRPF04869

T₃

3/23/93

$$9.16 + 7.94 + 7.84 = 24.94 / 26.66 = 93.548$$

T₂

$$7.50 + 8.06 + 8.56 + 8.20 = 32.32 / 34.57 = 93.5$$

T₁

$$8.30 + 7.96 + 7.64 + 8.14 = 32.04 / 34.28 = 93.46$$

$$T_1 = 100 + 40 = 140 \times 0.97 \times 0.935 = \underline{\underline{126.97}}$$

$$T_2 = 100 + 43 = 143 \times 0.97 \times 0.935 = \underline{\underline{129.7}}$$

$$T_3 = 143 \times 0.965 \times 0.935 = \underline{\underline{129.025}}$$

TG =

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CRPF04870